



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6028-195
Job Sheet 187922



Part No: D6028-195

Job Qty: 30 ea

Part Name: Crosstube Material, 7075-T73/T73511



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/20/18

Job Tracking No:

Due Date: 4/29/20

Created By: Chantal Lavoie

Type: Stock

Description:

Note: IPP Rev.A New issue JFS 17/11/03 Verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	30 pcs		4/29/20	0.00	0.00	Purchasing Start Up		At 19/10/07
110	Packaging	30 pcs		4/29/20	0.00	0.00	Packaging2		At 19/10/07
120	QC	30 pcs		4/29/20	0.00	0.00	QC18		61
140	Packaging	30 pcs		4/29/20	0.00	0.00	Packaging3		IE 9-89 100
150	QC21-SA	30 Ea		4/29/20	0.00	0.00	QC21		OCT 09 20

Part Op 100 - Issue P/O: 42117 a) Extrude as per Dwg D6028 length = 195" (Ref. D6028-195) b) Material: 7075-Descriptions: T73/T73510 (QQ-A-200/11 OR AMS 4617 OR AMS 4167 OR AMS 4166 OR ASTM B241) Seamless aluminum tube c) Minimum ultimate tensile strength = 68ksi d) Minimum yield tensile yield strength = 58ksi *****TWIST: MAXIMUM 3 DEGREE OVER TOTAL LENGTH as per dwg note 3***** Ensure material certification is attached
110 - Ensure material certification is attached
120 - Ensure Material certification comply to Dwg. D6028
140 - LOCATION :LG003

DEC 20 2018

DAS
13
9-8

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6028-195P	Crosstube Material, 7075-T73/T73511	30 pcs (1 ea)	100-Purchasing	5218587

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6028-195P	30	0	0

Part Specifications

Specifications could not be found.

Plex 12/20/18 2:20 PM dart.lavoie.chantal

A vertical scale with numbers 1 through 8. The numbers are arranged vertically from top to bottom. Tick marks are present at each number level.



WHERE XXX IS LENGTH IN INCHES
EG. 195" LONG TUBE: D6028-195

-
- A vertical scale with numbers 1 through 8. The numbers are arranged vertically from top to bottom. Tick marks are present at each number level.

A vertical scale with numbers 1 through 8. The numbers are arranged vertically from top to bottom. Tick marks are present at each number level.

RELEASED
2017-10-31
CCW 17-728

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PURCHASE ORDER



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042117

Supplier: ALU001-VU
Aluminiumwerk Unna AG
630-3033 SOUTH PARKER RD
AURORA, CO 80014 USA
Phone: 303 755 5672
Fax: 303 755 5936

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042117

PO Date: 12/20/18

Due Date: 4/29/20

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
JAN 03 2019

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
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PO042117

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	187922	D6028-195P	52844		Crosstube Material, 7075-T73/T73511 : 1) MATERIAL: 4.000" OD 7075-T73/T73511 SEAMLESS ALUMINUM TUBE PER (QQ-A-200/11 OR OR AMS 4617 OR AMS 4167 OR AMS 4166 OR ASTM B241) MINIMUM ULTIMATE TENSILE STRENGTH = 68 KSI MINIMUM YIELD TENSILE STRENGTH = 58 KSI 2) FINISH: NONE 3) TOLERANCES: O.D.: +/- 0.016" MEAN (+/- 0.024" INCLUDING OVALITY) LENGTH: XXX +0.57-0.000" STRAIGHTNESS: 0.010" DEVIATION / 12 " LENGTH TWIST: 0.250 DEVIATION / 12 " LENGTH, 3° MAXIMUM OVER TOTAL LENGTH OTHER DIMENSIONS PER DART QSI 018 EXCEPT AS NOTED receive pcs	Firmed	-	4/29/2018	30 pcs	0 pcs	30 pcs	\$1,204.00/pcs	\$36,120.00
Line Item Note EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE OUTSIDE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,NICKS,OR DENTS													
Grand Total:												\$36,120.00	

Handwritten signatures and initials



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PURCHASE ORDER
PO042117

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

CL

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Packing List Aluminiumwerk Unna AG



Page 1 of 1

Order		Article		Box marking	
Commission-No.:	74929	Outer Diameter (Inch):	0,000	DART AEROSPACE /	
Item No.:	100	Inner Diameter (Inch):	0,000	P.O. 042117 / D6028-195P	
Customer PO:	PO042117	Wall (Inch):	0,000	MADE IN GERMANY /	
Customer:	Dart Aerospace	Length (Feet):	16,25	DEST.: HAWKESBURY ONT, CANADA	
Date:	28.08.2019	Drawing:	0		
Comments: We hereby declare, that the wooden packing material are totally free from bark and apparently free from live plant pests.					

Box No.	Box dimensions			Total number of pieces and weights				Cast/Heat-Groups in the box			
	Length (Inch)	Width (Inch)	Height (Inch)	Pieces	Net lbs	Tare lbs	Gross lbs	Position	Pieces	Cast-No.	Heat-No.
1	208,662	22,441	22,441	16	954,6	289,908	1244,508		16	9893	No
2	208,662	22,441	22,441	15	888,462	279,987	1168,449		15	9893	No
Total:			3,444	31	1843,062	569,894	2412,957		31		

Abnahmeprüfzeugnis 3.1 - DIN EN 10204:2005

Inspection Certificate 3.1 - DIN EN 10204:2005 / Certificat de Reception 3.1- DIN EN 10204:2005

Kunde: Dart Aerospace Ltd.
Client:

1270 Aberdeen Street
K6A1K7 Hawkesbury, ON Canada

Zeugnisnummer:
Cert No. / No. du certificat:

P0042117

Bestellnummer:
Order No. / No. de commande

Auftrag: 74929/100

Our Reference/Notre Reference:

Produkt: Profile nahtlos gepresst
Product / Produit: Profiles seamless extruded

Spezifikation: AMS - QQ - A - 200/11A; -
Specification:

Werkstoff: 7075
Alloy/Alliage:

Zustand: T 73
Temper/État

Abmessung: x x
Size / Dimension: D6028-195P XA 12253

x 4953,000 mm

Lieferung

Delivered Material / Matériel délivré:

pcs.

31

lbs

1843

Country of Manufacture: Germany

Products are in accordance with applicable RoHS

1. Chemische Analyse

Chemical Analysis / analyse chimique

Other elements
each max. 0,05 %, total 0,15 %

Charge/ Cast No.	min. max.	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Zr	Bi	Sn	Ni	Na
		0,40	0,50	1,2 2,0	0,30	2,1 2,9	0,18 0,28	5,1 6,1	0,20						
9893/19		0,090	0,166	1,425	0,029	2,274	0,224	5,798	0,030	0,0020	0,0208	0,0010	0,0010	0,0056	0,0001

Hydrogen content: 0,13 **ccm/100 g Al** Elements without indication < 0,01 % **country of melt manufacturer: Germany**

2. Mechanische Eigenschaften

Mechanical Properties / Valeurs Mécaniques

Anforderungen Requirements	tensile (Rm) ksi	yield (Rp0,2) ksi	elongation 2" %	elongation A 4D %	Hardness HB	Electrical conductivity (IACS)
	68,0	58,0		7,0		
1	77,8	68,4		13,7		41,2
2	77,7	68,0		14,0		41,3
3	77,9	68,9		13,1		41,3

Corrosion protection Brayco 300

RMS 25 µ" - max. 15,6 µ"